

5/24

DART AEROSPACE LTD	Work Order:	23247
Description: Inner Aft Saddle	Part Number:	D5957
Drawing: D5957 Rev. A	Qty:	8

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Issue Work Order <i>Dwg. not required</i>	<i>df</i>	05.05.11	8
2	STORES	Issue material from stock: D6101-007 (7075-T7351) Cut Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: <i>B 2180A</i>	<i>gmL</i>	05/02/09	8
3	HAAS	Setup W/O No. Setup Inspection last completed by	<i>N/A</i>		
4	HAAS	Machine as per folio D5957 Ensure Batch Number is entered	<i>gmL</i>	05/02/09	8
5	HAAS	Deburr and Tumble	<i>gmL</i>	05/02/10	8
6	QC	Inspect Level 1 Fill Out Inspection Sheet	<i>gmL</i>	05/02/10	8
7	QC	Inspect Level 8 Audit Inspection Sheet	<i>En</i>	05/02/10	8
8	METAL	Acid etch and alodine as per QSI 005 4.1	<i>FF</i>	05.07.11	8
9	FINISHING	Powder Coat White (Ref. 4.3.5.1) as per Dart QSI 005 4.3	<i>ML</i>	05.07.11	8
10	QC	Inspect Level 3	<i>CL</i>	05/07/11	8
11	STORES	Pack in foam, identify and stock	<i>CL</i>	05/07/11	8
12	EXPEDITING	Close Work Order <i>139.87</i> Cost / Part : <i>139.87</i>	<i>df</i>	05/07/11	8

Rev	Date	Change	Revised By	Approved
A	97.03.05			
B	99.04.19	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	02.02.06	Added D part # and inspect level 21	NG	

RELEASED

02/02/06 *df*

03.05.16

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	23247
Description: Inner Aft Saddle	Part Number:	D5957
Inspection Dwg: D5957 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5957 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.748	1.749	1.748	1.750		
C	5.245	5.255		5.248	5.250	5.248	5.250		
D	6.995	7.005		6.999	7.006	6.998	6.999		
E	5.745	5.755		5.747	5.749	5.748	5.749		
F	4.745	4.755		4.747	4.748	4.749	4.748		
G	0.313	0.318	DT8686	✓	✓	✓	✓		
H	1.522	1.532		1.525	1.525	1.526	1.526		
I	3.048	3.058		3.052	3.053	3.053	3.053		
J	4.575	4.585		4.579	4.579	4.578	4.579		
K	0.313	0.318	DT8686	✓	✓	✓	✓		
L	0.240	0.260		0.251	0.250	0.250	0.250		
M	0.490	0.510		0.504	0.503	0.502	0.504		
N	0.240	0.260		0.251	0.250	0.249	0.250		
O	7.990	8.010		7.999	8.001	8.001	8.002		
P	0.240	0.260		0.250	0.256	0.256	0.257		
Q	0.307	0.312		0.310	0.310	0.310	0.310		
R	0.760	0.765		0.761	0.761	0.761	0.761		
S	0.490	0.510		0.502	0.505	0.501	0.502		
T	1.625	1.645		1.637	1.632	1.632	1.631		
U	2.000	2.020	DT8696 A/B	✓	✓	✓	✓		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>QML</i>
Date:	<i>05/07/09</i>

Audited by:	<i>En</i>
Date:	<i>05/07/10</i>

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	

RELEASED
03.06.18

DART AEROSPACE LTD	Work Order:	23247
Description: Inner Aft Saddle	Part Number:	D5957
Inspection Dwg: D5957 Rev. A		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D5957 Rev. A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
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B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		6.999	6.999	7.000	7.000		
E	5.745	5.755		5.749	5.749	5.749	5.748		
F	4.745	4.755		4.749	4.749	5.748	4.748		
G	0.313	0.318	DT8686	✓	✓	✓	✓		
H	1.522	1.532		1.527	1.526	1.526	1.526		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.578	4.581	4.580		
K	0.313	0.318	DT8686	✓	✓	✓	✓		
L	0.240	0.260		0.249	0.249	0.249	0.249		
M	0.490	0.510		0.503	0.503	0.503	0.503		
N	0.240	0.260		0.249	0.249	0.249	0.248		
O	7.990	8.010		8.001	8.001	8.002	8.002		
P	0.240	0.260		0.257	0.257	0.255	0.255		
Q	0.307	0.312		0.310	0.310	0.310	0.307		
R	0.760	0.765		0.761	0.761	0.761	0.761		
S	0.490	0.510		0.502	0.502	0.501	0.501		
T	1.625	1.645		1.631	1.634	1.636	1.630		
U	2.000	2.020	DT8696 A/B	✓	✓	✓	✓		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
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AE									
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AG									
AH									
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Measured by:	<i>ML</i>
Date:	05/07/10

Audited by:	<i>En</i>
Date:	05/07/10

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	

RELEASED
03.06.18

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 09, 2005
02:16 pm

Work Order No : 0023247
Project Name : D5957
Project For : WK524
Work Order Type : Main
Main WO Number :
House Part Number : D5957
Description : Saddle
Manufactured : Yes
Amount Req'd : 8
Amount Done : 0
Start Date : 05-09-05
Est Finish Date : 06-10-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00